

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 70.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002292**Date Inspected:** 13-May-2008**Project Name:** SAS Superstructure**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**Contractor:** Japan Steel Works**OSM Arrival Time:** 900**OSM Departure Time:** 1900**Location:** Muroran, Japan**CWI Name:****CWI Present:****Yes No****Inspected CWI report:** **Yes No N/A****Rod Oven in Use:** **Yes No N/A****Electrode to specification:** **Yes No N/A****Weld Procedures Followed:** **Yes No N/A****Qualified Welders:** **Yes No N/A****Verified Joint Fit-up:** **Yes No N/A****Approved Drawings:** **Yes No N/A****Approved WPS:** **Yes No N/A****Delayed / Cancelled:** **Yes No N/A****Bridge No:** 34-0006**Component:** Tower, Jacking and Deviation Saddles**Summary of Items Observed:**

The following report is based on METS observations at Japan Steel Works (JSW) in Muroran Japan. Current work: Casting, machining and nondestructive testing of Saddles.

Fabrication Building number 4

At 1500 hours, the QA inspector traveled to JSW fabrication shop number 4 and observed work in progress for the fit up of the base plate to the stem and rib plates for West Deviation Saddle W2-E1. One fitter was performing layout of rib locations on the base plate. Two JSW employees were fabricating the mounting frame that will be used to hold the saddle fabrication on a positioner for welding. The cut plates for completing castings W2-E1 and W2-E2 were stored in the area.

The following digital photographs illustrate observations of the activities being performed.

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Summary of Conversations:

On this date the QA inspector attended a meeting at Japan Steel Works Muroran facility. The QA inspector and METS personnel Mr. Ron Brasel met with JSW personnel Mr. Hiroshi Iga, General Manager, Mr. Kazunori Sato, Deputy Manager with seven other JSW personnel and Intertek Testing Services Certified Welding Inspectors Mr. Makhmud Ashadi and Mr. Chung Kuan.

The details of the fabrication plan to be submitted to Caltrans for engineering approval were discussed. Below are some of the issues that were discussed.

- a) The dimensional verification of the weld joint will be the responsibility of the Certified Welding Inspector with Intertek Testing Services and the remainder of dimension checks will be the responsibility of Intertek Testing Services QC.
- b) The daily inspection reports from both Intertek Testing Services and Nikko Inspection Services will be available daily for review in the Intertek Office.
- c) The use of welders not certified to AWS requirements to weld stays on the excess material that will be removed after welding is completed.
- d) The requirements of the contract Special Provisions as it applies to repair of cracked tack welds.
- e) The QA inspector noted that the section of the fabrication plan relating to the fillet welds in the weld access holes was not discussed.

Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Venkatesh Iyer, (858) 967-6363, who represents the Office of Structural Materials for your project.

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Inspected By:	Lanz,Joe	Quality Assurance Inspector
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Reviewed By:	Brasel,Ron	QA Reviewer
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